

Work Order ID 83394

Wednesday, April 18, 2012 8:29:32 AM

ASAP

83394

Page 1

Item ID: D3793-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 4/17/2012 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 4/30/2012 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/18 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(18)			
D3793	Rev A								

100

0.00

100

Waterjet

FLOW CNC Waterjet

304 - 040

FLOW WATER JET

Memo

1-Cut as per Dwg D3793

Dwg Rev: A

Prog Rev: A
 2-Deburr if necessary

0.00

B12-4-27

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B12-4-25

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

8/26/130

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					18	0		JB 12/05/01
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							8 12/05/01
Quality Control									
150		0.00							
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8-20 OVEN TEMPERATURE: 320 OF FINISH TIME: 8-50								

MU 7338

18X 12/05/01 ML

Dart Aerospace Ltd

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				18	0	BL252	
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>FP-1</u>	0.00				18	0	BL252	
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/5/34

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Picklist Print

Page 1

Wednesday, April 18, 2012 8:29:37 AM

Work Order ID: 83394

83394

Parent Item: D3793-3

D3793-3

Parent Item Name: Wearshoe

Start Date: 4/17/2012

Required Date: 4/30/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

371.3609

1.2828

21.60505

23,

M304S20GA

**

B12-4-25

304/316 .040 Sheet

Location

Loc Qty

Loc Code

001

52.6444105

121192

52.6444105

MAT020

318.7165

117933

27.3442

118400

6.3723

118964

30.2

119346

29.8

121380

225

121380

(18)

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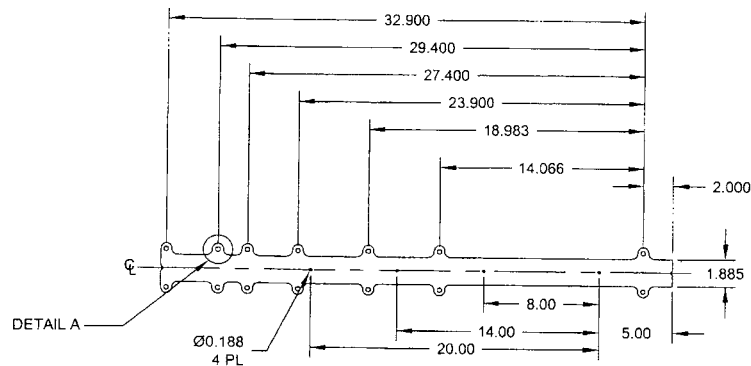
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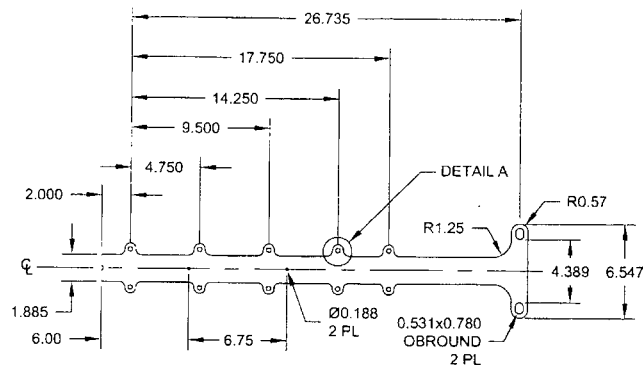
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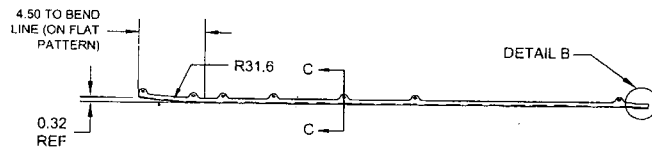
NOTE: Date & initial all entries



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83394 MLJ

12/04/18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

RELEASED
08-05-23/18

A	NEW ISSUE	PH	08.05.14	
REV.		DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	PH			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.	PH		D3793	SHEET 1 OF 2
APPROVED	PH		TITLE	SCALE
DE APPR.	PH		WEARSHOE	NTS
DATE	08.05.14		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIALITY IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

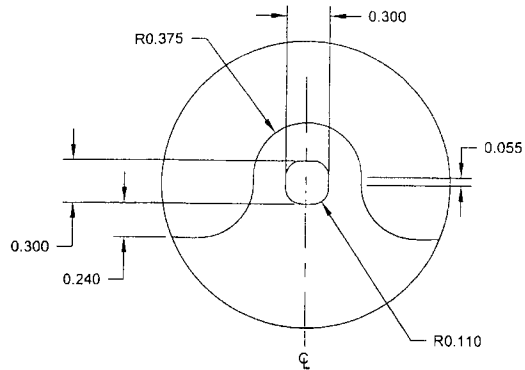
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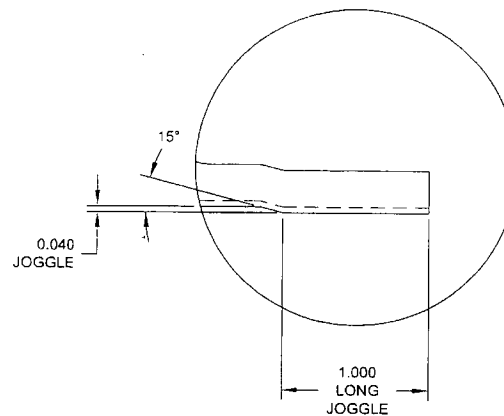
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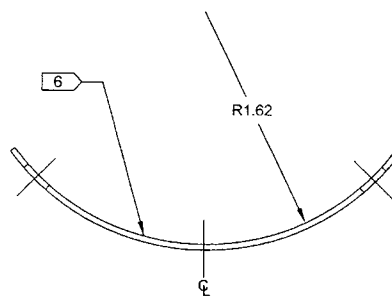
NOTE: Date & initial all entries



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

03394

RELEASED
08-05-23/18

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	DS	D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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